

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017844**Date Inspected:** 03-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (11DE-11EE)**

This QA inspector along with QA inspector Mr. Manjunath S Math performed the dimensional survey inspection to verify the root gap and offset on the transverse splice weld of segment 11DE and segment 11EE. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11DE to Segment 11EE – PP 106 to PP 107

**OBG # TRIAL ASSEMBLY YARD (11AE-11BE)**

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the WT stiffener to verify the vertical and horizontal offset. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11AE to Segment 11BE

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### OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U-Rib to verify the offset. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BE to Segment 11CE

### OBG # OUTSIDE YARD (12BE)

This QA inspector along with QA inspector Mr.Manjunath S Math performed the dimensional survey inspection after heat straightening on the deck panel diaphragm to verify the flatness and plumbness. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 12BE – PP 113

### OBG # OUTSIDE YARD (12AE)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection after heat straightening on the longitudinal diaphragm to verify the offset and sweep. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 12AE – PP 111 to PP 112

### OBG # TRIAL ASSEMBLY YARD (10BW)

This QA inspector witnessed the final bolt tension verification on the road barrier angle of segment 10BW. The torque wrench S/N was X02-776. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 91.5:

M22 X 120 – DHGM 220053 – 440 NM

### OBG # WEST GATE OF BLASTING SHOP (SP5 & SP6)

This QA inspector performed Visual Inspection Testing (VT) prior to blasting along with QA inspector Mr. Manuel Teall on the service platform members SP5-1 and SP6-1. This QA Inspector signed a green tag # 15177 for this date. The members are identified as follows:

SPB5-1 to 5, 5A, 6 to 13, 21 and 22

SPB6-1 to 5, 5A, 6 to 13, 21 and 22

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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